

Date: Tuesday, 7/18/2006 3:00:53 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 27970  
 Estimate Number : 11058  
 P.O. Number : N/A  
 This Issue : 7/18/2006 S.O. No. : N/A  
 Print Rev. : NC  
 First Issue : N/A Type : PURCHASED PARTS  
 Previous Run : 27506  
 Drawing Name : 02.500 SUPPORT  
 Part Number : D28921  
 Drawing Number : D2892 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : N/A  
 Due Date : 8/18/2006 Qty: 8 Um: Each  
 Written By :  
 Checked & Approved By : 06-07-19  
 Comment : Est. C 02.11.25 Added P/O KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1721

Description: D6104-003

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

Blank size makes (2) D2891-1

3.25 x 3.8

2.0 D6104003 17-4 SS Roundbar 3.25"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Support

3.0 PACKAGING-1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI LATHE

Turn blank for Haas as per Fello FA082

INSPECT ALL DIM TO DIM SHEET

5.0 QC1



Comment: INSPECT ALL DIM TO DIM SHEET

Receive &amp; Inspect for

Transit damage 6/6/06 (8)

5b Inspect level 5

En 06/10/15

# Process Sheet

mer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.500 SUPPORT

Job Number: 27970

Part Number: D28921

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BAND SAW BAND SAW



Comment: BAND SAW  
Machine as per Folio FA082  
Tumble & Deburr

HAAS

Sn 06/10/20 x 1 set

7.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ep 06/10/20 x 1 set

8.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Int 06/10/20 1 set

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FL 06/10/23

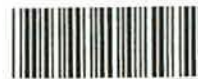
10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06-10-31 (1 set)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

PC 4/11/01 2mcp

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

(1)  
06/11/01

Job Completion



in 06/11/01

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	27990
<b>Description: Ø2.500 Support</b>	<b>Part Number:</b>	D2892-1
<b>Inspection Dwg: D2892 Rev. A</b>		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
<b>Lathe Section</b>									
A	2.524	2.529		2.529	2.529	2.529	2.529		
B	3.702	3.722		3.714	3.712	3.711	3.716		
C	2.814	2.834		2.822	2.823	2.825	2.822		
D	0.718	0.738		0.726	0.732	0.733	0.725		
E	0.090	0.110		0.094	0.095	0.090	0.093		
F	2.714	2.734		2.712	2.719	2.722	2.724		
G	2.029	2.049		2.033	2.032	2.038	2.035		
H	3.214	3.234		3.222	3.220	3.222	3.223		
I	0.913	0.933		0.920	0.920	0.923	0.920		
J	0.022	0.042		0.037	0.032	0.032	0.032		
K	0.090	0.110		0.094	0.102	0.098	0.099		
L									
<b>HAAS Section</b>									
AA	0.115	0.135		0.130	0.138				
AB	0.290	0.310		0.300	0.304				
AC	0.040	0.060		0.046	0.046				
AD	0.115	0.135		0.125	0.129				
AE	0.240	0.260		0.244	0.249				
AF	0.188	0.193	DT8706	0.189	0.189	0.189	0.189		
AG	0.240	0.260		0.250	0.250	0.250	0.250		
AH	1.126	1.146		1.146	1.143				
AI	0.454	0.474		0.465	0.468				
AJ	0.240	0.260		0.250	0.250	0.250	0.250		
AK	0.053	0.073		0.063	0.063	0.063	0.063		
AL	0.257	0.262	DT8883	0.260	0.260	0.260	0.260		
AM	1.663	1.683		1.677	1.678				
AN	0.053	0.073		0.063	0.063	0.063	0.063		
AO	0.022	0.042		0.032	0.032	0.032	0.032		
AP	2.779	2.789		2.783	2.781				
AQ									
AR									
<b>Accept/Reject</b>									

Measured by:	EN
Date:	06/10/20

Audited by:	Jul
Date:	06/10/20

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	+

**VALBRUNA**

SLATER STAINLESS, INC.  
2400 Taylor Street West, P.O. Box 630  
Fort Wayne, Indiana USA 46801  
Phone: 260-434-2892 Fax: 260-434-2905

**Product Certification Report**Report Number: **4078840**

Certified on May 31, 2005 Page 1 of 1

Order I.D. <b>0500940 001</b>		Order Date <b>4/29/05</b>		Commodity Code <b>408853-0</b>	
Dim 1 <b>3.2500</b>	Dim 2 <b>.0000</b>	Dim 3 <b>.0000</b>	Heat I.D. <b>239178</b>	Customer I.D. <b>001155</b>	Customer Purchase Order <b>CE5900</b>
Product Shape <b>Rounds</b>			Product Surface <b>HR &amp; Rough Turned</b>		Customer Grade <b>630</b>
Length (Inches) <b>132.000 Min. 156.000 Max.</b>			Bill of Lading # <b>401376</b>	Weight	

**Ship To**

**COPPER AND BRASS SALES**  
**415 STATE PARKWAY**  
**SCHAUMBURG, IL 60173**

**Sold To**

**VALBRUNA CORP.**  
**31 IRON HORSE ROAD**  
**OAKLAND, NJ 07436**

**Lifts: 0096****AISI 630****CONDITION A****ASTMA 564-02****ASMESA 564 01 ED 2002 ADD****AMS 2303E****AMS 5643Q****CHEMICAL ANALYSIS**

C	Mn	P	S	Si	Cr	Ni	Mo	Cu	N	Cb	Ta	Cb+Ta
.039	.57	.026	.017	.54	15.60	4.60	.18	3.35	.04	.29	.001	.29

**HB****353****TENSILE PROPERTIES****CAPABILITY**

HB	TS (PSI)	.2%YS (PSI)	%EL(2")	%RA	AGE(F)
433	206000	178300	14.1	50.9	900

**MAGNETIC PARTICLE TEST**

**FREQ SEV**  
**AVG .00 .00**

**MACRO ASTM E340/E381****MACRO****OK****OK****PERCENT FERRITE****% FERRITE****AVG 1.0**

Free of mercury and low melting alloy contamination.

Maxx stainless.

Chemical testing performed to one or several of the following ASTM methods: E415, E572, E1019, E1085, E1086.

Material melted in Italy, manufactured in the United States.

Material conforms to listed specifications.

Quality system is compliant with ISO 9001:2000. Produced in accordance with EN 10204 3.1B.

**COPPER AND BRASS SALES****SOLD TO:****DATE: 7/21 QTY. 72 lbs****CUSTOMER PO: 000072****SHIPPER NO: 42097****BY: 8**

Results relate only to the items tested. Certification shall not be reproduced except in full, without written approval of Valbruna Stainless Inc. The recording of false, fictitious, or fraudulent statements on this document may be punished as a felony under federal statutes, including Federal law, Title 18, Chapter 47. Consult material safety data sheet (MSDS) for hazard info. I hereby certify that the reported figures are correct as contained in the records of the corporation.

Manager Laboratory Services

Dennis Hackett



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

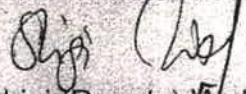
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	DSK076	Support as per Dwg DSK076 D6104-003 B28388	2068
8	DSK076	Support as per Dwg DSK076 D6104-003 B28077	2068
10	DSK076	Support as per Dwg DSK076 D6104-003 B26715	2068
20	DSK077	Support as per Dwg DSK077 D6104-003 B28389	2068
8	DSK077	Support as per Dwg DSK077 D6104-003 B27970	2068
7	DSK077	Support as per Dwg DSK077 D6104-003 B28078	2068
14	DSK080	Support as per Dwg DSK080 D6104-011 B27266	2068

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi (Regula) Walz

Vankleek Hill, September 20, 2006